



# ACERINOX-ROLDAN-INOXFIL

## WELDING WIRE

### ACX 655

AWS/ASME:A5.9: ER 316LSi  
EN ISO 14343-A: 19 12 3 L Si

Revision 0 February 14

#### Chemical composition:

ACX 655	C	Mn	P	S	Si	Cr	Ni	Mo	N	Cu
AWS/ASME	0.03	1.00-2.50	0.030 Max.	0.030 Max.	0.65-1.00	18.00-20.00	11.00-14.00	2.00-3.00	-	0.75 Max.
EN-ISO 14343-A	0.03	1.00-2.50	0.030 Max.	0.020 Max.	0.65-1.20	18.00-20.00	11.00-14.00	2.50-3.00	-	0.50 Max.
ACX 655	0.02	1.55-1.95	0.023 Max.	0.007 Max.	0.75-0.95	18.40-18.80	12.10-12.40	2.55-2.75	0.30-0.50	0.15 Max.

#### Mechanical properties table: Standard properties INOXFIL :

	0,2% Yield point (MPa)	Tensile strength (MPa)	Elongation (%)
Welding wire MIG-TIG	≤1600	≤1700	≤8

#### Minimal mechanical properties according to the standard:

EN	Grade (equivalence)	Mechanical properties according to EN 14343- A		
		Re 0,2% min. N/mm <sup>2</sup> (Yield point)	Rm min. N/mm <sup>2</sup> (Tensile strength)	A% Min. % (Elongation)
19 12 3 L Si		320	510	25

#### Approvals

VdTÜV, CE, CPR, DB (Approvals for MIG/TIG wire)

#### Conditions – Diameter range

##### AVAILABLE DIAMETERS mm.

WELDING TYPE	0,80	1,00	1,20	1,60	2,00	2,40	3,20	4,00
MIG/MAG (GMAW)								
TIG								



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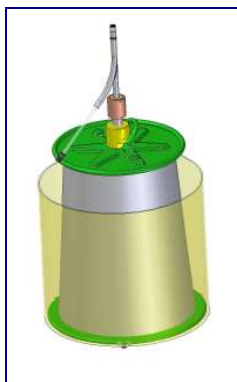
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### Packaging conditions

PRODUCT	PACKAGING	CAPACITY (Kg.)
MIG/MAG (GMAW)	Plastic/metal spool SD-300/K300	12-15
	Blue, black metall spool.	15
	Conical metallic spool (2X), and conical Wooden spool (2XM)	350/ 280
TIG (GTAW)	Tube diameter 50 mm.	5
	Rectangular box	5



Conical packaging

#### PACKAGING: (CONICAL SPOOL)

##### Product characteristics and properties.

Packaging developed by INOXFIL as an alternative to the Marathon Pack.

This packaging assures an absolute guarantee of nonstop winding.

It guarantees a stable welding.

Very simple to handle. Instructions are enclosed, if necessary, INOXFIL S.A. will send a technician in order to install it correctly.

INOXFIL S.A. is currently supplying welding wire in packaging (2X – 2XM) to some of the best known manufacturers of exhaust systems.

This packaging requires a special unwinding tool that will be provided by INOXFIL (Left as borrowed).

Weight up to 350/280Kg.

Returnable packaging for the 2X and non-returnable for the 2XM.

The wire is delivered without tension, dead drawn.

Less changes during the welding process because of the weight.

Requires minimal attention.

Requires minimal maintenance.

Doesn't generate any residue (Very ecologic)

It saves space in your warehouse.

### Welding position

PA, PB, PC, PD, PE, PF (PG for MIG)



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### Surface Conditions:

The wire can be supplied with a dull or bright finish; free of surface defects and is degreased in a continuous line. In some cases the wire can be delivered with a specially designed lubricant to improve the behavior during the unwinding and guide process (optimum weld fluency), this also minimizes the consumption of the welding nozzles, and prevents the excess of spatters on the weld.

### Characteristics

Grade ER 316 L Si (ACX 655) is a welding wire recommended to weld MIG/MAG (GMAW) grades such as 18Cr12Ni3Mo and similar such as AISI 316L. The resistance of the weld to hot cracking improves with the Si content. The high content of Silicon improves the arc stability, the fluency and the aspect of the weld. In some cases it can be used as TIG welding wire.

It presents a high pitting corrosion resistance in chlorides environment, this grade, due to the low content of C (carbon) reduces the formation of carbide precipitations in the weld zone. This grade presents also a good behavior against intergranular corrosion at conditions up to 350°C by oxidizing solutions.

Keep the material in a dry place and avoid humidity.

The attached data only can be considered like a general information and it can be modified without previous advice.